

Work Order ID 121045

121045

Page 1

June-16-14 1:17:02 PM

Item ID: D3456-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Washer

100 100
50
50

Start Date: 6/16/14

Start Qty: 50.00

Cust Item ID:

Required Date: 6/16/14

Req'd Qty: 50.00

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 14-06-17

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3456	Rev A

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Issue P/O: 24713 P/N: 91525A120 per Dwg D3456Possible
Supplier: McMaster-CarrMaterial release note is required

CD 14/06/20 100

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

PC 14/06/20 (100)

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

SP6
4/6/25

100

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Suspected _____ Unapproved _____				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>					
Root Cause		Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector	
Design	<input type="checkbox"/>												
Doc/Data	<input type="checkbox"/>												
Equip/Tooling	<input type="checkbox"/>												
Handling/Pre	<input type="checkbox"/>												
Material	<input type="checkbox"/>												
Operator	<input type="checkbox"/>												
Offset/Setup	<input type="checkbox"/>												
Process	<input type="checkbox"/>												
Supplier	<input type="checkbox"/>												
Training	<input type="checkbox"/>												
Transport	<input type="checkbox"/>												
Unapproved	<input type="checkbox"/>												
FAULT CATEGORY													
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function			<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence				<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled

Work Order ID 121045

121045

Page 2

June-16-14 1:17:02 PM

Item ID: D3456-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Washer

Stop

NS2

Start Date: 6/16/14

Start Qty: 50.00

50

Cust Item ID:

Required Date: 6/16/14

Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: STO40

0.00

100X DAS
28
9-89

JUN 26 2014

130

Packaging

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

ML5 14-06-26

140

QC

Quality Control

0.00

MF
14-6-26

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS														
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>													
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>													
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>													
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>														
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector									
Design																		
Doc/Data																		
Equip/Tooling																		
Handling/Pre																		
Material																		
Operator																		
Offset/Setup																		
Process																		
Supplier																		
Training																		
Transport																		
Unapproved																		
FAULT CATEGORY																		
Landing Gear			General															
			<input type="checkbox"/>	Bending							<input type="checkbox"/>	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced
			<input type="checkbox"/>	Centre Not Concentric							<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up
			<input type="checkbox"/>	Cracks							<input type="checkbox"/>	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure
			<input type="checkbox"/>	Crimp/Kink/Ripple/Wave							<input type="checkbox"/>	Burr	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld
			<input type="checkbox"/>	Cuffs							<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled
			<input type="checkbox"/>	Crushing							<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>	
			<input type="checkbox"/>	Heat Treat							<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other
			<input type="checkbox"/>	Inspection Strip in Tube							<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>		<input type="checkbox"/>	
			<input type="checkbox"/>	Marks/Chatter							<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>		<input type="checkbox"/>	
			<input type="checkbox"/>	Turning Sequence							<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>	
			<input type="checkbox"/>	Wave/Twist in Tube							<input type="checkbox"/>	Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>	



Picklist Print

June-16-14 1:17:02 PM

Page 1

Work Order ID: 121045

121045

Parent Item: D3456-1

D3456-1

Parent Item Name: Washer

Start Date: 6/16/14

Required Date: 6/16/14

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP A05.10.03New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
91525A120		Purchased		No		100	Each	150.0000	1	50	100	6/16/14/2014	

91525A120

washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST	150	
115051	150	

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

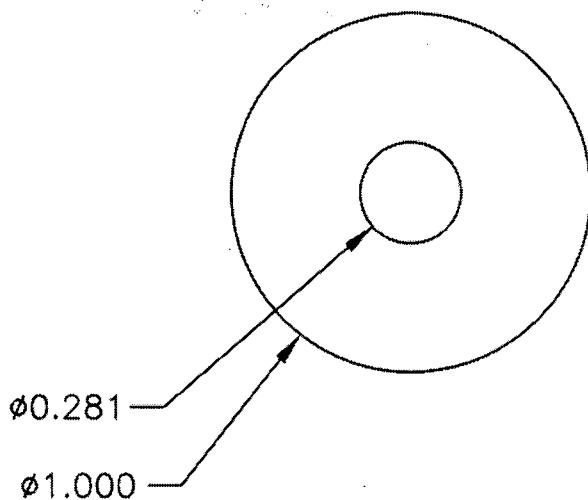
Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
Part No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
NCR No. _____			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
Suspected Unapproved <input type="checkbox"/>		Large Fab <input type="checkbox"/>		Composite <input type="checkbox"/>		Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function								
			<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence								
			<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge								
			<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled								
			<input type="checkbox"/> Other								



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>ff</i>	APPROVED <i>ff</i>	DRAWING NO. D3456	REV. A SHEET 1 OF 1
DATE 05.09.01		TITLE WASHER	SCALE 2:1
A	05.09.01	NEW ISSUE	

RELEASED
05-09-06-ff

SPECIFICATION CONTROL DRAWING



D3456-1 WASHER

- 1) MATERIAL: 316 STAINLESS STEEL, 0.050" THICK
- 2) MAY PURCHASE McMaster-Carr P/N 91525A120
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121045MC5
1406-17

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24713**

Purchase Order Date 6/20/2014
PO Print Date 6/20/2014

Page Number 1 of 4

Order From : **VU-MCM001**
MCMMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Ship To : **DART AEROSPACE LTD**
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name
Vendor Phone 330 995 5500

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency USD
FOB FCA - (Free Carrier)

Ship To Contact
Ship To Phone
Ship Via: FedEx PI collect
Ship Acct:

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	63215K34	Bearing	6/24/2014 Yes 6/24/2014	20.00 Each		\$17.24	\$344.80
		AS PER DWG D2611 REV. C B121166				Line Total:	\$344.80
2	63215K52	Bearing Spherical	6/24/2014 Yes 6/24/2014	20.00 Each		\$15.62	\$312.40
		AS PER DWG D3965 REV. B B121239				Line Total:	\$312.40
3	91525A120	washer	6/24/2014 Yes 6/24/2014	100.00 Each		\$0.27	\$26.64
		AS PER DWG D3456 REV.A B121045				Line Total:	\$26.64

Note:

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO24713

Page 1 of 2

Order Placed By
Chantal Lavoie

06/20/2014

McMaster-Carr Number
5397315-01

Line	Description	Ordered	Shipped
1	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick Your Part Number: N/A	20 Each	20
	Unit Price: \$17.24 Extended Price: \$344.80		
2	63215K52 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 1/4" ID, 21/32" OD, 11/32" Ball Thick Your Part Number: N/A	20 Each	20
	Unit Price: \$15.62 Extended Price: \$312.40		
3	91525A120 Type 316 Stainless Steel Large-Diameter Flat Washer, 1/4" Screw Size, 1" OD, .04"-.06" Thick, Packs of 25 Your Part Number: N/A	4 Packs	2 - 702
	Unit Price: \$6.66 Extended Price: \$26.64		
4	9928K53 Impact-Resistant UHMW Polyethylene U-Channel, 1" Base X 3/4" Legs, 1/4" Thick Your Part Number: N/A	16 Feet	5 - 23
	Unit Price: \$2.28 Extended Price: \$36.48		

Dart Aerospace Ltd

EXP
INV



34 lbs
8 lines

Fr

FW1WPB31
06/20/2014
10:43/11:32
264
Cycle 34

